

Work Order ID 120615

Friday, June 06, 2014 11:19:59 AM

120615

Page 1

Item ID: D4085-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Placard

Stop ***NS2***

Start Date: 6/13/2014 Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/13/2014 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: CX Date: 14/06/06 Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4085

C

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 2512

E-mail or Ship electronic file and or dwg to vendor

Manufacture as per Dwg and supplied files

Possible supplier: Studio Letrage

Material release note is required.

CX 14/06/09 20

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

P14/6/12 (20)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC6- Inspect dimensions to drawing 0.00

0.00

120

QC

Memo

0.00

Quality Control

68-6
27
SYD
4/6/13

20

130 Identify as per dwg & Stock Location: ST087 0.00

0.00

130

Packaging

Memo

0.00

Packaging

20X

DAS
28
9-89

JUN 13 2014

140 QC21- Final Inspection - Work Order Release 0.00

0.00

140

QC

Memo

0.00

Quality Control

MLJ

1406-16

MLJ 1406-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

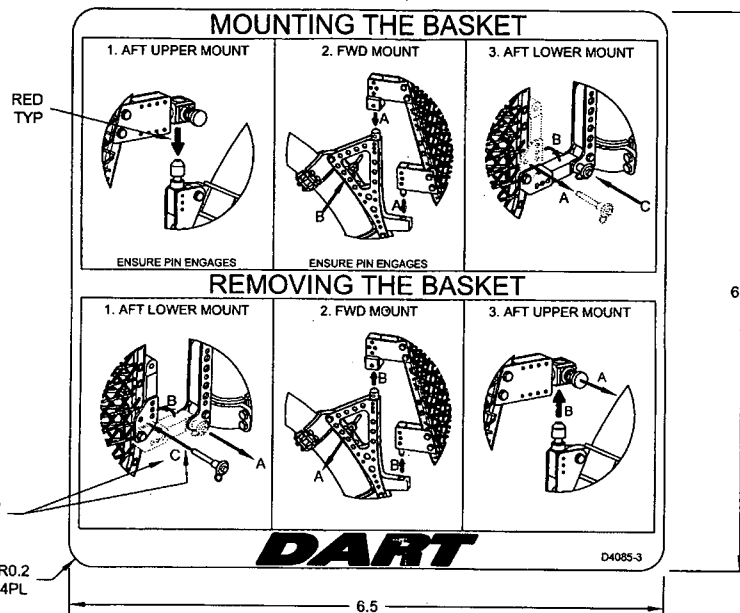
Work Order update only ☐

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D4085-3 PLACARD, INSTRUCTIONS

NOTES:

- 1) MATERIAL: BLACK LETTERS AND GRAPHICS WITH RED ARROWS AND LOGO ON WHITE BACKGROUND AND ADHESIVE BACK. MANUFACTURED FROM 3M, 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) USE FILE D4085-3C.eps FOR GRAPHICS

CX 14106104
W/O: 120615

RELEASED
2010-07-16
W/S

DESIGN	DPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	D4085	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLACARD, INSTRUCTIONS	NTS
DATE	10.06.25	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24512**

Purchase Order Date 6/9/2014

PO Print Date 6/9/2014

Page Number 3 of 4

Order From :

VC-STU001

Ship To : DART AEROSPACE LTD

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 632 5449

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

6	D4085-3P	Placard, Instructions	6/16/2014	20.00	\$4.00	\$80.00
			Yes	Each		
			6/16/2014			

AS PER DWG D4085 REV. C
B120615

Line Total: \$80.00

8	D3301-3P	Placard	6/16/2014	12.00	\$6.67	\$80.00
			Yes	Each		
			6/16/2014			

AS PER DWG D3301 REV. A
B120454

Line Total: \$80.00

9	D3428-1P	Placard	6/16/2014	12.00	\$6.67	\$80.00
			Yes	Each		
			6/16/2014			

AS PER DWG D3428 REV. A
B120584

Line Total: \$80.00

Note:

6/9/2014

Studio de Lettrage

210 Main Street W
Hawkesbury, Ontario K6A 2H6

INVOICE

Invoice No.: 22395
Date: 06/10/2014
Ship Date: 06/12/2014
Page: 1
Re: Order No. WO12750

Sold to:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Ship to:

Dart Aerospace Ltd
Hawkesbury, Ontario

632-9577

Business No.: 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
			PO# 24512	H		
		12	D2137P	H	6.6667	80.00
		12	D3012-3P	H	6.6667	80.00
		12	D3012-5P	H	6.6667	80.00
		40	D2371-1P	H	2.0000	80.00
		12	D3997-23P	H	6.6667	80.00
		20	D4085-3P	H	4.0000	80.00
		12	D3301-3P	H	6.6667	80.00
		12	D3428-1P	H	6.6667	80.00
			Chantal Lavoie			
			Subtotal:			640.00
			H - HST 13%			
			HST			83.20

****Certificate of Conformity****

Customer:

Studio de Lettrage 2001

Purchase Order #:

PO# 24512

Packing Slip #:

WO# 12750

Part #:

Serial #:

Description: D2137, D3012-3P,
D3012-5P, D3671-1P, D3997-23P,
D4085-3P, D3301-3P, D342K-1P

Quantity:

9 batches.

Certification:

We hereby certify that:

1. The above the listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

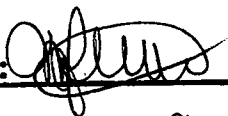
Authority:

AVERY

APPROVAL:

Natasha B. Lafleche

Signature:



Title:

Production Coordinator

DATE:

June 11th 2014.

PRODUCT DATA SHEET



Avery® IPM™ 2031

issued: 01/04/2005

Introduction

Avery® IPM™ 2031 is a high quality pressure-sensitive vinyl film, designed for use on wide format inkjet printers. Avery® IPM™ 2031 has excellent printing properties, allowing crisp print quality with bright and vibrant colours. Avery® IPM™ 2031 offers rapid ink drying and a water-resistant material. It combines good adhesion during its life and easy removal afterwards.

Description

Facefilm: 80-micron premium white calendered, topcoated vinyl.
Adhesive: removable, acrylic based
Backing paper: one side coated kraft paper, 140 g/m²

Features

- Excellent printability
- Vibrant and bright colours
- Crisp print quality
- Spray water resistant with specific pigmented inks
- Good adhesion, excellent removability
- Warranty on outdoor durability

Recommendations for use

A wide variety of full-colour graphics for indoor - and **short/medium term outdoor** applications such as posters, murals, displays, exhibition stands, vehicle graphics etc. Avery® IPM™ 2031 is suitable for application to a wide variety of substrates and will remove cleanly for up to 1 year after application.

IPM media should be handled with care as any surface contamination may affect the print quality. Media should be processed in an environment of 15-25°C and 30-70% relative humidity. After drying, the finished prints should be wrapped in polyethylene film and despatched flat or rolled with the printed side facing outwards. To protect prints against water, UV/light and abrasion, overlamination with a clear film is recommended. For specific details of Avery® DOL combinations, refer to "Technical Bulletin 5.3. Recommended combinations of Avery® Overlaminate and Avery® Digital Print Media"

Always test your combination of Avery® IPM™ medium, inkjet printer and inks prior to commercial use.

Compatibility

Avery® IPM™ 2031 is compatible with a broad selection of inkjet printers, when printing with pigmented, water based inks. For specific details refer to "Technical Bulletin 5.6 Avery Dennison Inkjet Print Media - Printer compatibility".

Durability:

Avery® IPM™ 2031 is warranted for outdoor use in conjunction with pigmented outdoor inks from HP, Encad and Colorspan. The warranted period varies from type of application and type of overlaminate from 18 months up to 5 years. For full details, see our Avery® IPM™ Outdoor warranty.



www.averygraphics.com

Graphics Division
Rijndijk 88, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538

PRODUCT CHARACTERISTICS

Avery® IPM™ 2031

Physical properties

Features	Test method ¹	Results
Caliper, facefilm	ISO 534	80 µm
Gloss	ISO 2813, 20°	1%
Dimensional stability	DIN 30646	0.3 mm. max
Adhesion, initial	FINAT FTM-1, stainless steel	180 N/m
Adhesion, ultimate	FINAT FTM-1, stainless steel	260 N/m
Flammability		Self extinguishing
Accelerating ageing	DIN 53587, 500h exposure	No negative impact on film
Shelf life	Stored at 22° C/50-55 % RH	Performance
Removability		2 years
Not when applied to: Nitro-cellulose paints, ABS, Polystyrene, certain types of PVC		up to 1 year
Durability ²	Overlaminated with DOL 4300	5 years
	Overlaminated with DOL 1000, DOL 1100	
	with overlaps	3 years
	Overlaminated without overlaps	
	for static applications only	2 years
	Without overlaminate and used for static,	
	Non-abrasive application ONLY	18 months

Only when printed with ENCAD GO, HP and Colorspan pigmented inks and when properly applied in accordance with our application instructions. Only applicable for vertical exposure.

Temperature range

Features	Results
Application temperature	Minimum: +10°C
Service temperature	-20°C to +80°C

Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use.

All technical data are subject to change. In case of any ambiguities or differences between the English and foreign versions of these Conditions, the English version shall be controlling.

Warranty

Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing.

All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

1) Test methods

More information about our test methods can be found on our website.

2) Durability

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



www.averygraphics.com

Graphics Division
Rijndijk 86, P.O. Box 118
2394 ZG Hazerswoude – The Netherlands
Tel +31 71 3421500 – Fax +31 71 3421538